DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-022195 Address: 333 Burma Road **Date Inspected:** 25-Mar-2011

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See Below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** OBG

Summary of Items Observed:

CWI Inspector: Mr. Zhen Hua

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 14

Segments 13E and 14E

This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-089. This QA Inspector observed a welding current of approximately 175 amperes (amps) the base materials were preheated with electrical heaters and Mr. Wang Zhengbin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-133. This QA Inspector observed a welding current of approximately 190 amps the base materials were preheated with electrical

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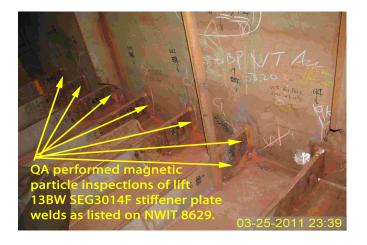
heaters and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Guanglin, stencil 044779 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-155. This QA Inspector observed a welding current of approximately 180 amps the base materials were preheated with electrical heaters and Mr. Zhao Guanglin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Kuai Wenshan, stencil 054013 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-177. This QA Inspector observed a welding current of approximately 195 amps the base materials were preheated with electrical heaters and Mr. Kuai Wenshan appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

Segment 13 West

ZPMC presented QA personnel with "Notification of Witness Inspection" document number 8629 item 20 that stated ZPMC was requesting Caltrans to perform visual (VT) and magnetic particle (MT) inspections of OBG segment 13W stiffener plate welds in Bay 14. This QA Inspector performed random MT and VT inspections of the following welds: SEG3014F-119~122, 124~127, 129~132, 134~137, 139~142, 144~147, 149~152. For additional information on these inspections see this QA Inspector's TL6028 magnetic particle test report and the photograph below.





Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

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Inspected By: Dawson,Paul Quality Assurance Inspector **Reviewed By:** Riley,Ken QA Reviewer